

Work Order ID 152433

152433

Page 1

Monday, October 24, 2016 11:41:04 AM

Item ID: D2153 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Door Prop
 Start Date: 11/9/2016 Start Qty: 18.00 ***18*** ***18*** Cust Item ID:
 Required Date: 11/16/2016 Req'd Qty: 18.00 ***18*** Customer:
 Reference:

Approvals: Process Plan: **DAS 21 9-89** Date: **OCT 24 2016** Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2153	Rev A1								
100	PURCHASING	0.00							
100									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: 34091 Gas Spring P/N: SL13-10 (10lb) Possible supplier: Spring Lift Corporation **Note: Do not ship by air****Allow an extra 7 to 10 business days for shipping**Material release note is required								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.06							
Packaging	Ensure Material Release Note is attached								
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control	Inspect Test Spring is 10lb								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By _____
					Lead hand / Supervisor Approval Verification
					QC / QA Coordinator Approval
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____		

Monday, October 24, 2016 11:41:04 AM

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[illegible]

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WORK ORDER NON-CONFORMANCE / UPDATE

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Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER :			

152433

Monday, October 24, 2016 11:41:04 AM

N900040100

Stop ***NS2***

18

18

Required Date: 11/16/2016 **Req'd Qty:** 18.00

Run Start *NR1*

Stop ***NR2***

NR2

**Insp.
Stamp**

160

0.03

DAS
21
8-89

DEC 15 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Page 1

Work Order ID: 152433

152433

Parent Item: D2153

D2153

Parent Item Name: Door Prop

Start Date: 11/9/2016

Required Date: 11/16/2016

Start Qty: 18.00

Required Qty: 18.00

Comments: IPP: E 02.07.08 Re-format KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2153P *D2153P* Door Prop		Purchased	No			130	Each	0.0000	1	18.36 36x		NOV 01 2016	DAS 26 9-89
D3015-3 *D3015-3* Locknut		Manufactured	No			130	Each	274.0000	2	36.72		16/12/09	DAS 36 9-89
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				FG		18							
				95758		8							
				96151		10							
				ST015		256							
				150873		156							
				151623		100							
NAS1149D0563J *NAS1149D0563.J* Washer		Purchased	No			130	Each	1,265.000	2	72 36.72		16/12/09	DAS 36 9-89
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				GA		117							
				m125807		2							
				m133769		115							
				ST263		1049							
				m135470		349							
				m135774		700							
				ST269		99							
				m128257		99							

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
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Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
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Misidentified ☐	Past Due ☐								

Picklist Print

Monday, October 24, 2016 11:41:04 AM

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Work Order ID: 152433

152433

Parent Item: D2153

D2153

Parent Item Name: Door Prop

Start Date: 11/9/2016

Required Date: 11/16/2016

Start Qty: 18.00

Required Qty: 18.00

SL69-BS

Purchased

No

100

Each

129.0000

2

3872

SI 69-BS

16/12/08

Ball Stud

DAS
36
9-89

Location

Loc Qty

Loc Code

GA

129

M132260

3

M134239

26 27

M135261

100

27
45

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

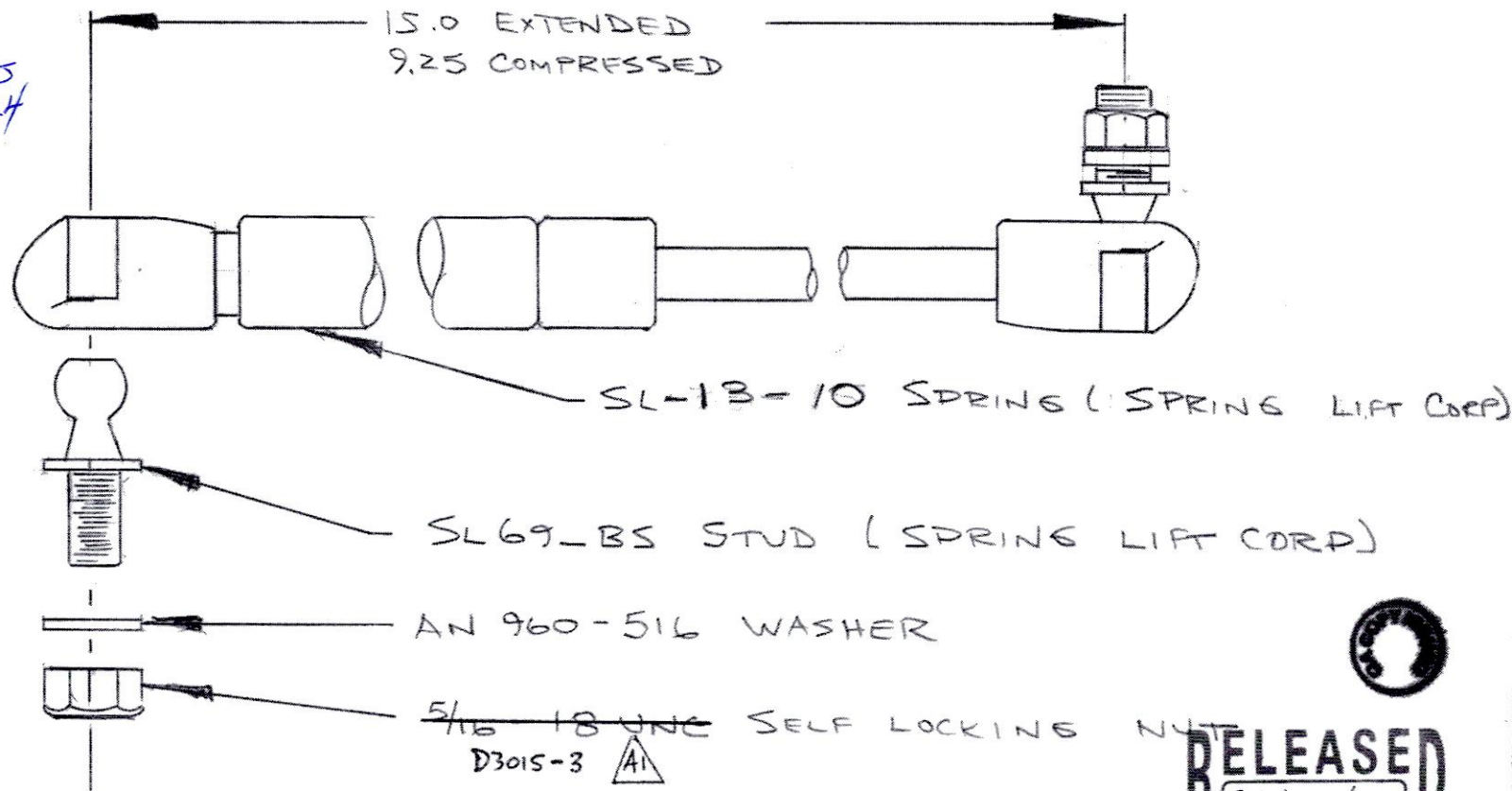
Work Order update only ☐

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Description Work Order Deviation				Disposition					
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Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
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Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐								
Misidentified	☐	Past Due	☐	OTHER :							

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 152433 MLJ
16-10-24



RELEASED
96/07/16

01.05.01 CHANGE TO D3015-3 SL 13-10 WASHER SL 33-15		A1 A CP	REVISION DRAWN APPROVED	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.	RIVET CODE SHALL BE PER NAS 523 BASIC CODE DIA. DASH NO. 14-HEAD REAR SIDE 17-HEAD RAR SIDE D-DIMPLE DIGIT-NO OF SHEETS C-COUNTERSINK LENGTH DASH NO 14-SPOTWELD BASIC CODES 84-MS20470AD 88-MS20476AD	PART NO. CONTRACT NO. DRAWN DESIGN STRESS CHECKED CLIENT	ITEM DATE HATTON 27.2.72 HATTON 1/1/74	DESCRIPTION GAS SPRING ASSEMBLY	MATERIAL DART AERO ACCESSORIES INC. VANCOUVER CANADA	SPEC./VENDOR DZ153	
REQUIREMENTS — UNLESS OTHERWISE SPECIFIED GENERAL 1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125 μ 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER INCH — 5 — 7142 5. HOLES PER AND 10287		LIMITS 1. TOLERANCES — .001 ± .030 2. ANGLES .001 ± .010 3. PARALLELISM .0025 4. ECCENTRICITY .005 MAX 5. STAMPE TRY ABOUT ALL MAT' CENTRE LINES .005		REPORT ALL DISCREPANCIES — DO NOT SCALE		DART DART AERO ACCESSORIES INC. VANCOUVER CANADA		TITLE GAS SPRING ASSEMBLY		CODE DZ153	REV A



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO34091

Purchase Order Date 10/28/2016 9:16:04 AM

PO Print Date 10/28/2016

Page Number 1 of 2

Order From :

ATTWOOD
25349 NETWORK PLACE
CHICAGO, IL 60673-1253
US

VU-ATT001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED
OCT 28 2016

Contact Name

Vendor Phone 616-897-2285

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

USD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D2153P AS PER DWG D2153 REV. A B152433 ATTWOOD P/N: SL13-10 (10LB)	Door Prop	11/9/2016 Yes 11/9/2016		36.00 Each	\$13.05	\$469.80
DAS 26 9-89 NOV 01 2016							Line Total: \$469.80
3	71401-45 Procurement Quality Clauses A004 faa-pma/tso A005 right of entry A016 personnel qualification A025 certification of conformance A040 notification of quality escape A043 retention of quality documents	PROCUREMENT QUALITY CLAUSES	11/9/2016 No 11/9/2016		1.00	\$0.00	\$0.00
Line Total: \$0.00							\$0.00

Note:

10/28/2016



MotorGuide
NEVER STOP.

CUST: 68580 MST: 80606-00
COLLECT 151793240

BILLTO: DART AERO LTD.
REQ: 10/31/16

PRO NO: 290000360
SHIP VIA: FEDEX STANDARD OVE
BOL: 00226970005691953

FREIGHT: _____

F ATTWOOD CORP
R
O 1016 NORTH MONROE
M LOWELL

MI 49331-0260

INCOTERMS: EXW SHIPPER DOCK

DART AERO LTD.
T 1270 ABERDEEN STREET
O

HAWKESBURY ON K6A 1K7

CRTS: 1 PO#: P034091

WGT: 12 DATE: 10/28/16

SPUR: 9

LABEL NO:

--ROUTING GUIDE INFO --

--SHIPPED--

CRTS	QTY	LOCATN	UM	PART# / UPC	DESCRIPTION / SKU	LN	QTY	WGT
1	36	W03911	EA	SL13-10-1	SS SPRNG 15" EXTC 10# BL	1	36	12

DAS
38
9-89

DAS
26
9-89

NOV 01 2016